DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-014838
Date Inspected: 08-Jun-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:				**CWI Present:**	☐ Yes	☑ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Trial Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 8BE (Cope Holes)

This QA Inspector performed Dimension Control Inspection for the Cope Holes at Floor Beam to Side Panel and Floor Beam and Bottom Panel at Working Point (E4) and Work Point (E3) from West Side and Longitudinal Diaphragm Cope Hole East West side of each Panel Point (PP) 65, PP 66 and PP 67 for Segment 8BE the Inspection was performed against the ABF Inspection Report No. CWAHIR-8AE-02 Dated June 07, 2010. The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader and Engineer for review.

Segment 8CE (Cope Holes)

This QA Inspector performed Dimension Control Inspection for the Cope Holes at Floor Beam to Side Panel and Floor Beam and Bottom Panel at Working Point (E4) and Work Point (E3) from West Side and Longitudinal Diaphragm Cope Hole East West side of each Panel Point (PP) 68, PP 69, PP 70 and PP 71 for Segment 8CE the

Inspection was performed against the ABF Inspection Report No. CWAHIR-8BE-02 Dated June 07, 2010. The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader and Engineer for review.

Segment 9AE (Cope Holes)

This QA Inspector performed Dimension Control Inspection for the Longitudinal Diaphragm (LD) Cope Holes at Floor Beam to Bottom Panel at Work Point (E3) from East Side at Panel Point (PP) 72 for Segment 9AE the Inspection was performed against the ABF Inspection Report No. CWAHIR-9AE-01 Dated Jan 15, 2010. The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader and Engineer for review.

Segment 9CE (Cope Holes)

This QA Inspector performed Dimension Control Inspection for the Floor Beam to Bottom Panel Cope Holes at Work Point (E4) from West Side at Panel Point (PP) 79 for Segment 9CE the Inspection was performed against the ABF Inspection Report No. CWAHIR-9CE-01 Dated April 12, 2010. The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader and Engineer for review.

Segment 10BW (Cope Holes)

This QA Inspector performed Dimension Control Inspection for the Floor Beam to Bottom Panel Cope Holes at Work Point (W4) from West Side at Panel Point (PP) 89 and PP 90 for Segment 10BW the Inspection was performed against the ABF Inspection Report No. CWAHIR-10BW-01 Dated June 03, 2010. The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader and Engineer for review.

Segment 8AE, 8BE and 8CE (Side Panel to Corner Assembly)

This QA Inspector performed Dimension Control Inspection the Side Panel to Corner Assembly Longitudinal Weld Skin Flatness from Panel Point (PP) 61 to PP 70 Cross Beam Side. The measured readings were recorded on Dimension Control Plan form (DCP) and submitted to the Lead and Engineer for review.

Segment 8AW, 8BW and 8CW (Side Panel to Corner Assembly)

This QA Inspector performed Dimension Control Inspection the Side Panel to Corner Assembly Longitudinal Weld Skin Flatness from Panel Point (PP) 61 to PP 70 Cross Beam Side. The measured readings were recorded on Dimension Control Plan form (DCP) and submitted to the Lead and Engineer for review.

Segment 8AW, 8BW and 8CW (Side Panel to Corner Assembly)

This QA Inspector performed Dimension Control Inspection the Side Panel to Corner Assembly Longitudinal Weld Skin Flatness from Panel Point (PP) 61 to PP 70 Counter Weight Side. The measured readings were recorded on Dimension Control Plan form (DCP) and submitted to the Lead and Engineer for review.

Segment 8AW (Side Panel T-Ribs)

This QA Inspector performed Dimension Control Inspection for the Side Panel T-Ribs at PP 68, PP 69 and PP 70 Cross Beam Side for Segment 8AW FL3 area and observed the following.

At PP 68 at 19 th T-Rib (Numbering Reference taken from LD towards Side Panel Corner Assembly side) observed Horizontal offset 7 mm after rectification at CJP weld when measured by 1 meter Straight Edge.

At PP 70 at 6th T-Rib, 9th T-Rib, 10th T-Rib, 14th T-Rib, 16th T-Rib, 17th T-Rib and 19th T-Rib (Numbering Reference taken from LD towards Side Panel Corner Assembly side) observed Horizontal offset as 4 mm, 5 mm, 4 mm, 6 mm, 4 mm, 4 mm and 5mm after rectification at CJP weld when measured by 1 meter Straight Edge.

At PP 68, PP 69 and PP 70 Verified whether shim plates are installed as per the dimension recorded on May 03, 2010 by the QA Inspector.

The measured readings were recorded on spread sheet and submitted to the Lead and Engineer for review.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer